

Split



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DAS
19
9-05

D2807-041
Job Sheet 210261



Part No: D2807-041

Job Qty: 10 pcs

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/2/20

Job Tracking No:

Due Date: 6/5/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Purchasing	10 pcs		6/4/20	0.00	0.00	Purchasing - 1			JUN 03 2020
							Purchasing - 2			
							Purchasing - 3			
110	Packaging 2-1 - Receive - B4B	10 pcs		6/4/20	0.00	0.00	Packaging 2 - 1 - B4B			JUN 03 2020
							Packaging 2 - 2 - B4B			
							Packaging 2 - 3 - B4B			
							Packaging 2 - 5 - B4B			
							Packaging 2 - 4 - B4B			
							Packaging 2 - 6 - B4B			
							Packaging 2 - 7 - B4B			
							Packaging 2 - 8 - B4B			
							Packaging 2 - 9 - B4B			
							Packaging 2 - 10 - B4B			
							Packaging 2 - 11 - B4B			
							Packaging 2 - 12 - B4B			
							Packaging 2 - 13 - B4B			
							Packaging 2 - 14 - B4B			
							Packaging 2 - 15 - B4B			
							Packaging 2 - 16 - B4B			
							Packaging 2 - 17 - B4B			
							Packaging 2 - 18 - B4B			
							Packaging 2 - 19 - B4B			
							Packaging 2 - 20 - B4B			
							Packaging 2 - 21 - B4B			
							Packaging 2 - 22 - B4B			
							Packaging 2 - 23 - B4B			
							Packaging 2 - 24 - B4B			
							Packaging 2 - 25 - B4B			
							Packaging 2 - 26 - B4B			
							Packaging 2 - 27 - B4B			



Container No: S280949



Part: D2807 - 041

Job No: 210261

Serial No/Batch: S280949

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/03/20

Plex 6/2/20 3:00 PM Dart.lajeunesse.marie

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
120 QC 6	10 pcs	6/4/20	0.00 0.00	QC 6 - 9		
				QC 6 - 68		
				QC 6 - 61		
				QC 6 - 40		
				QC 6 - 81		
				QC 6 - 82		
130 Small Fab - 2 - B4B	10 pcs	6/5/20	0.00 0.20	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
				Small Fab - 8 - B4B		
				Small Fab - 9 - B4B		
				Small Fab - Various 1 - B4B		
140 QC 5	10 pcs	6/5/20	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
				QC 5 - 82		
150 Packaging 3-1 - Stock - B4B	10 pcs	6/5/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		

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JUN 03 2020

JUN 03 2020

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JUN 04 2020

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JUN 05 2020

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
160	QC 21 - SA	10 pcs	6/5/20	0.00 0.00	

DAS
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505

JUN 05 2020

Part Op **100** - Purchasing - Issue P/O: _____ Order as per Dwg D2807 Possible supplier Support
 Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
110 - Receive & Inspect for Damage & Mat'l Certs - Ensure Material Release Note is attached
120 - QC6- All purchased or subcontracted products
130 - Small Fab - 1-install D3671-1 as per dwg D2807
140 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6/15-164/50-115N	Gas Spring D2807-041	10 pcs (1 ea)	100-Purchasing	S 280948
D3671-1	Placard	10 pcs (1 ea)	130-Small Fab - 2 - B4B	

GA129
45 qts 14

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	6/15-164/50-115N	10	0	0
130-Small Fab - 2 - B4B	D3671-1	10	14	0

Part Specifications

Specifications could not be found.

Plex 6/2/20 3:00 PM Dart.lajeunesse.marie

SPECIFICATION CONTROL DRAWING

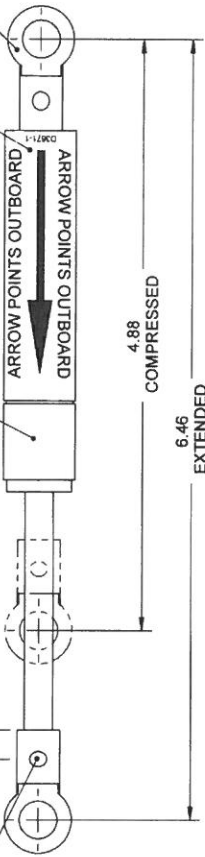
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 210265 M15
20-06-02

8
AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING
(ALTERNATE ONLY) D2807-3
BOTH ENDS

8
D2807-5
OR
(ALTERNATE ONLY) D2807-1

8
0.24 TO CRIMP
(TYP)

8
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.169 LBS
 - 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING: D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING. UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AJ		
DRAWN	AJ		
CHECKED	ME		
MFG. APPR.	ME		
APPROVED	ME		
DE APPR.	ME		
DATE	07.12.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D2807			
REV. E			
SHEET 1 OF 3			
TITLE GAS SPRING			
SCALE NTS			
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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																															
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details:						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046528



Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046528
PO Date: 6/2/20
Due Date: 6/5/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Fedex P1 Overnight
Pynt Terms: Net 30

Freight Terms:
Special Comments:

E-MAILED
2020-06-02

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	210261	6/15-164/50-115N	D2807 REV. E DAS 82 9-89			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed x16	-	6/5/20	16 pcs	0 pcs	16 pcs	\$72.13/pcs	\$1,154.08
													Grand Total: \$1,154.08	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 6/2/20 3:18 PM Dart.Guerin.Kimberley



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

June 2, 2020

This is to certify that the parts listed below meets specifications as required by your order.

16 Units : D2807-041 #210261 Stainless Gas Spring

Country of Manufacture: Canada
Date of Manufacture : June 02 2020
This product is ROHS compliant.

DAS
82
9-89

Purchase Order # **POHB046528**
Invoice # 22640

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President

Packing Slip

LS TECHNOLOGIES INC

1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

Bill to:

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

P.O. No.

Date

Invoice #

POHB046528

2020-06-02

22640

Ship to:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship

Via

2020-06-02

Fed-Ex

Qty

Description

16 D2807-041 # 210261 Stainless Gas Spring

Shipping Via FED EX Tracking # 770607195363

RECEIVED

JUN 03 2020

DART AEROSPACE LTD.

Order checked by :